

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008766**Date Inspected:** 27-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG & TOWER Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 1

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #028 located on Floor Beam FB204 – 047. Welder is identified as 216575. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

FCAW process welding of weld joint #024 located on Floor Beam FB205 – 047. Welder is identified as 216575. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #004 located on Floor Beam FB3069 – 001. Welder is identified as 062438. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW process welding of weld joint #003 located on Floor Beam FB3073 – 003. Welder is identified as 215676. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #007 located on Floor Beam FB3069 – 001. Welder is identified as 062438. ZPMC QC is identified as Xiang Feng Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232– Tc – U4b – F.

FCAW process welding of weld joint #005 located on Floor Beam FB3029 – 001. Welder is identified as 045209. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #003 located on Traveler Rail TR10A – 001. Welder is identified as 215689. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #004 located on Traveler Rail TR10A – 001. Welder is identified as 217185. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

BAY 6

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

1. BP3001-001-013; 016; 21; 33; 007; 012; 020; 040 – Green Tag # 0010386
2. BP3002-001-013; 015; 021; 029; 007; 020; 009; 028 – Green Tag # 0010385

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #7B located on WD1 – A305 – 65M – 4. Welder is identified as 037780. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

SMAW process welding of weld joint #44 located on WD1 – A305 – 77M – 1. Welder is identified as 069493. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

SMAW process welding of weld joint #1A located on WD1 – A305 – 65M – 4. Welder is identified as 066457. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

WPS – B – T – 3212 – Tc – U5b – 1.

SMAW process welding of weld joint #7B located on WD1 – A305 – 65M – 1. Welder is identified as 066481. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

SMAW process welding of weld joint #1A located on WD1 – A305 – 65M – 1. Welder is identified as 066456. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U5b – 1.

BAY 7

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #009 located on Deck Plate DP3011 – 001. Welder is identified as 051246. ZPMC QC is identified as Shen Jian Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4132.

FCAW process welding of weld joint #006 located on Deck Plate DP3061 – 001. Welder is identified as 222396. ZPMC QC is identified as Shen Jian Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4132.

FCAW process welding of weld joint #034 located on Deck Plate DP3061 – 001. Welder is identified as 051246. ZPMC QC is identified as Shen Jian Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
